

Work Order ID 60347

July 6, 2010 11:42:10 AM

ADAP 11



Page 1

Item ID: D2175-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle LH

Start Date: 7/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 7/06/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2175

Rev E

100

0.00



Waterjet

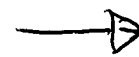
FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2175 Dwg Rev: E Prog Rev: E 2-
Deburr if necessary



m 10 07 06 (6)

110

0.00



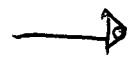
QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control



m 10 07 06 (6)

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S 10/07/07

(16)

-Work Order ID 60347

July 6, 2010 11:42:10 AM



Page 2

Item ID: D2175-1

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Start Date: 7/06/10

Start Qty: 6.00

Required Date: 7/06/10

Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur Stack

0.00

0.00

7M.L w/07/07

6X

140



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D2175

0.00

0.00

8 w/07/07

C

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 w/07/07

16

Work Order ID 60347

July 6, 2010 11:42:11 AM

Page 3

Item ID: D2175-1

Accept

Revision ID:

Item Name: Angle LH

Setup Start

Stop

Start Date: 7/06/10 Start Qty: 6.00

Required Date: 7/06/10 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

⑥ BR 10-7-7.

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

⇒ JM 10/07/07 6 6

180

Identify as per dwg & Stock Location

0.00

Packaging

Memo

0.00

Packaging

GA
B 60345

8 10/07/07 6

- Work Order ID 60347

July 6, 2010 11:42:11 AM

Page 4

Item ID: D2175-1

Accept

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Start Date: 7/06/10 Start Qty: 6.00

Required Date: 7/06/10 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10577
ME
10-7-7

Picklist Print

July 6, 2010 11:42:09 AM

Page 1

Work Order ID: 60347

Parent Item: D2175-1

Parent Item Name: Angle LH



Start Date: 7/06/10

Required Date: 7/06/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP 04.06.09 Reformat KJ/RF
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	107.8000	0.4722	2.982316			



2024-T3 .063 sheet



Location

Loc Qty

Loc Code

MAT22

107.8

113866

18.5

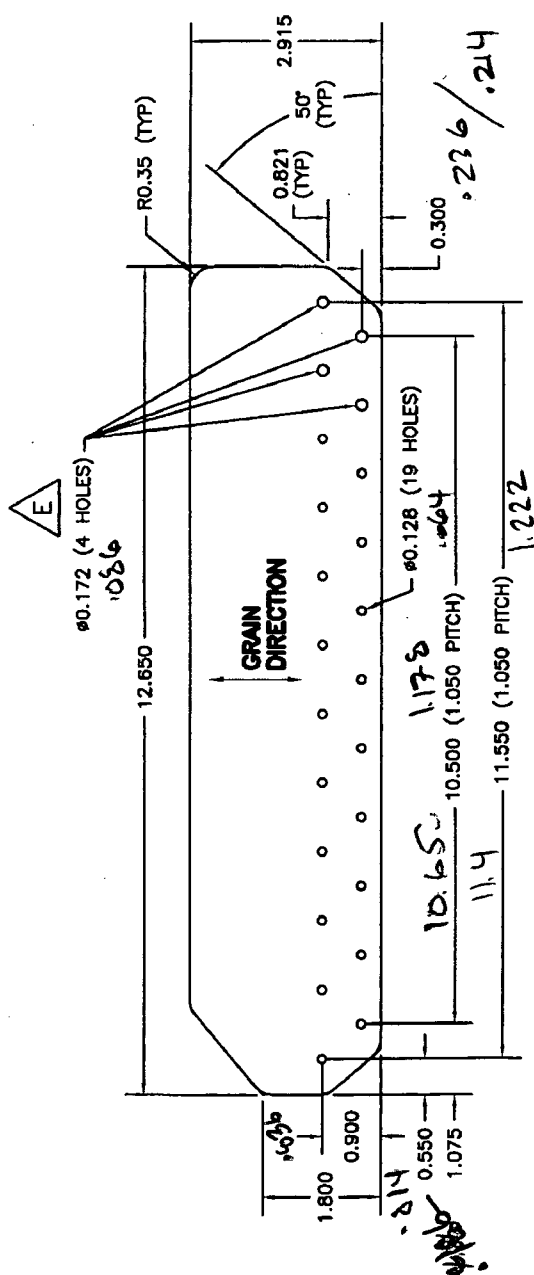
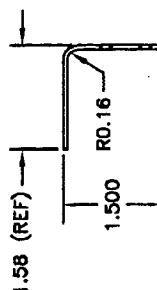
114351

89.3

MA 10-07-06

DART

DESIGN RF	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2175	REV. E SHEET 1 OF 1
DATE 06.09.25	TITLE ANGLE	SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	CHANGED DIMENSION	
C	00.09.11	UPDATE FINISH SPEC	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC HOLE DIA TO $\phi 0.172$, 4 HOLES	

RELEASED
06.10.13**D2175-1F FLAT PATTERN****D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSIONS ARE IN INCHES

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